

Date: Monday, 03/11/2008 8:54:40 AM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE LH (209)
Job Number : 43135	
Estimate Number : 11596	
P.O. Number :	Part Number : D29171
This Issue : 03/11/2008 S.O. No. :	Drawing Number : D2917 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 37420	Material :
Written By : <u>JLM 08.11.03</u>	Due Date : 10/11/2008 Qty: 4 Um: Each
Checked & Approved By :	
Comment : Est A 04.07.16 New Issue KJ/JLM	
set B 07.08.07 ECN930 EC verified by: JLM	

Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description :
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1.0	D6102010	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

6061-T6 8.25x7.95x2.5

Cut blanks: 2.500" x 8.250" x 7.950" grain along 7.950"

Material: 6061-T6/T651 (QQ-A-250/11)

(D6102-010)

Identify as D2917-1

Batch: B37600 x 3 pcsB21368 x 1 pcsJ.F. 08/11/07 (4)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program batch number

Machine Step No 1 as per Folio FA436 and visually inspect as per Dwg D2917 & attached Dimension Sheet

Machine Step No 2 as per Folio FA436 and visually inspect as per Dwg D2917 & attached Dimension Sheet

Machine Step No 3 as per Folio FA436 and visually inspect as per Dwg D2917 & attached Dimension Sheet

Deburr

ml 08/11/08(4)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per Dwg D2917 & attached dimension sheet

J.F. 08/11/17 (4)

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Seq. #: Machine Or Operation: Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mf 08/11/08

(4)

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

88 08/11/17

(4)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-h

08/11/17

(4x)

7.0

POWDER COATING

POWDER COATING



M109152



(4x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:30
320°F
2:00

M-h

08/11/17

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

sls

08-11-17

(x4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST424

NS

08/11/18

(x4)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/18

Job Completion



mf 08-11-18

DART AEROSPACE LTD	Work Order: 43135
Description: Saddle LH	Part Number: D2917-1
Inspection Dwg: D2917 Rev. A1	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2917 Rev. A1 and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.175	0.205		.187	.188	.188	.188		
B	0.090	0.110		.102	.108	.108	.108		
C	0.250	0.270		.256	.255	.255	.256		
D	1.599	1.619		1.610	1.610	1.610	1.610		
E	0.180	0.220		.180	.184	.184	.183		
F	0.277	0.297		.278	.281	.280	.279		
G	1.385	1.400		1.392	1.390	1.392	1.394		
H	3.170	3.230		3.204	3.210	3.210	3.212		
I	0.175	0.217		.188	.190	.190	.190		
J	0.470	0.530		.500	.500	.500	.500		
K	1.498	1.508		1.505	1.502	1.502	1.503		
L	4.436	4.446		4.442	4.440	4.440	4.440		
M	0.257	0.262	DT8683	.259	.260	.260	.260		
N	1.225	1.235		1.232	1.227	1.227	1.227		
O	1.103	1.113		1.105	1.105	1.105	1.105		
P	0.470	0.530		.500	.500	.500	.500		
Q	0.438	0.443	DT8682	.440	.440	.440	.440		
R	0.490	0.510		.500	.500	.500	.502		
S	1.745	1.755		1.750	1.750	1.750	1.750		
T	7.990	8.010		8.000	8.000	8.000	8.002		
U	3.495	3.505		3.500	3.500	3.500	3.500		
V	0.175	0.205		.190	.194	.192	.192		
W	2.000	2.010		2.003	2.003	2.003	2.003		
X	0.760	0.765		.760	.760	.760	.760		
Y	0.307	0.312		.310	.310	.310	.310		
Z	0.615	0.635		.623	.627	.628	.626		
AA	0.177	0.197		.190	.190	.186	.188		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>ML</i>	Audited by: <i>SP</i>
Date: 08/11/08	Date: 08/11/17

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM	